

Date: Thursday, 04/12/2008 9:10:52 AM
 User: Julie Dawson

Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: GAS SPRING		
Job Number	: 43901			Part Number	: D2807041		
Estimate Number	: 13065			Drawing Number	: D2807 REV E		
P.O. Number	:			Project Number	: N/A		
This Issue	: 04/12/2008	S.O. No.	:	Drawing Revision	: E		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: PURCHASED PARTS	Due Date	: 21/12/2008		
Previous Run	: 35828			Qty:	40	Um:	Each
Written By	:			10			
Checked & Approved By	: JCD 08.12.05			10			
Comment	: Est: D 07.11.12 ecn1019, replaces D2807 DD Est Rev:E 08-02-12 ECN 1111 DD verified by: ec			EC verified by			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: <u>7765</u> <u>C 208/12/04</u> Order as per Dwg D2807 Possible supplier:Lift Support Technologies, Saskatoon,Canada P/N 6/15-164/50-115N Material release note is required		
2.0	615 16450 115N	Gas Spring
Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) SUPPORT PROP		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached		
4.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK		
5.0	D36711	Placard
Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) PLACARD batch: <u>43945</u> <u>88 08/12/18 X10</u>		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/12/2008 9:10:52 AM
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Process Sheet

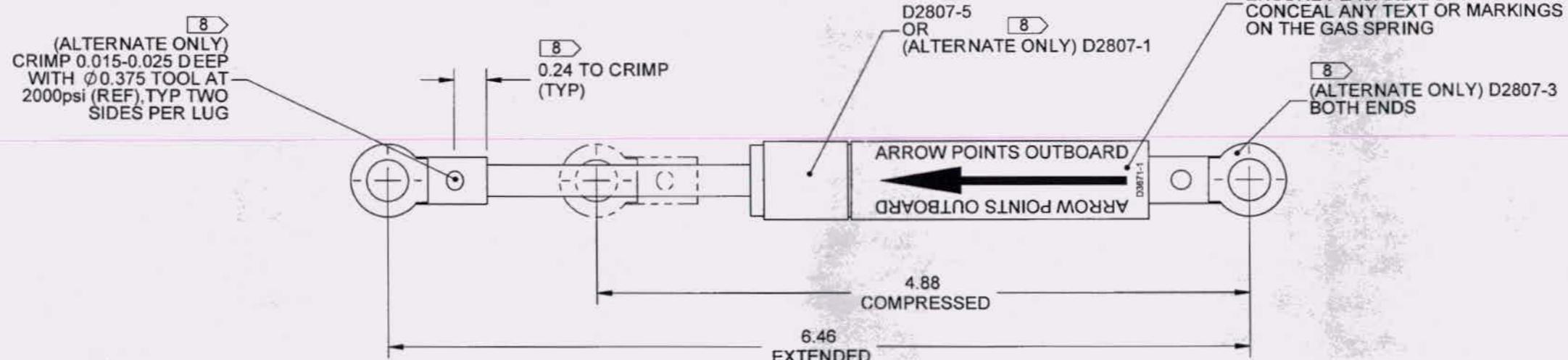
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: GAS SPRING
Job Number: 43901		Part Number: D2807041
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-install D3671-1 as per dwg D2807 <i>08/12/10</i> @		
7.0	QC5 	INSPECT WORK TO CURRENT STEP <i>08/12/10</i> @
Comment: INSPECT WORK TO CURRENT STEP 8.0 PACKAGING 1 		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>48</i> <i>8/12/10</i> <i>10X</i>		
9.0	QC21 	FINAL INSPECTION/W/O RELEASE  <i>08/12/22/10</i>
Comment: FINAL INSPECTION/W/O RELEASE Job Completion  <i>MF 08-12-19</i>		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING**D2807-041 GAS SPRING**

RELEASED
05-12-2010
TO
DRAFTING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 43901

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

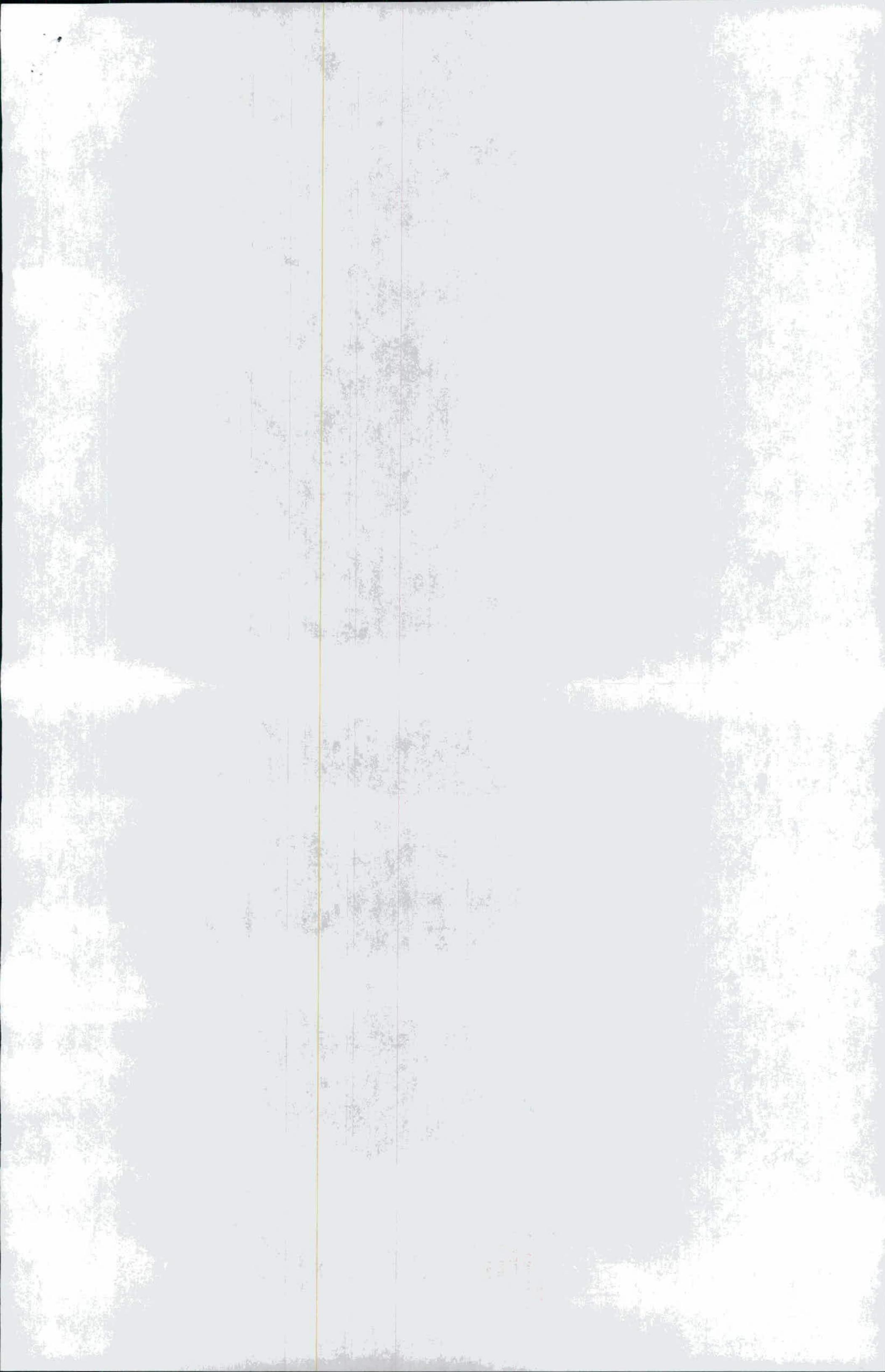
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2) (WEIGHT: 0.176 LBS)

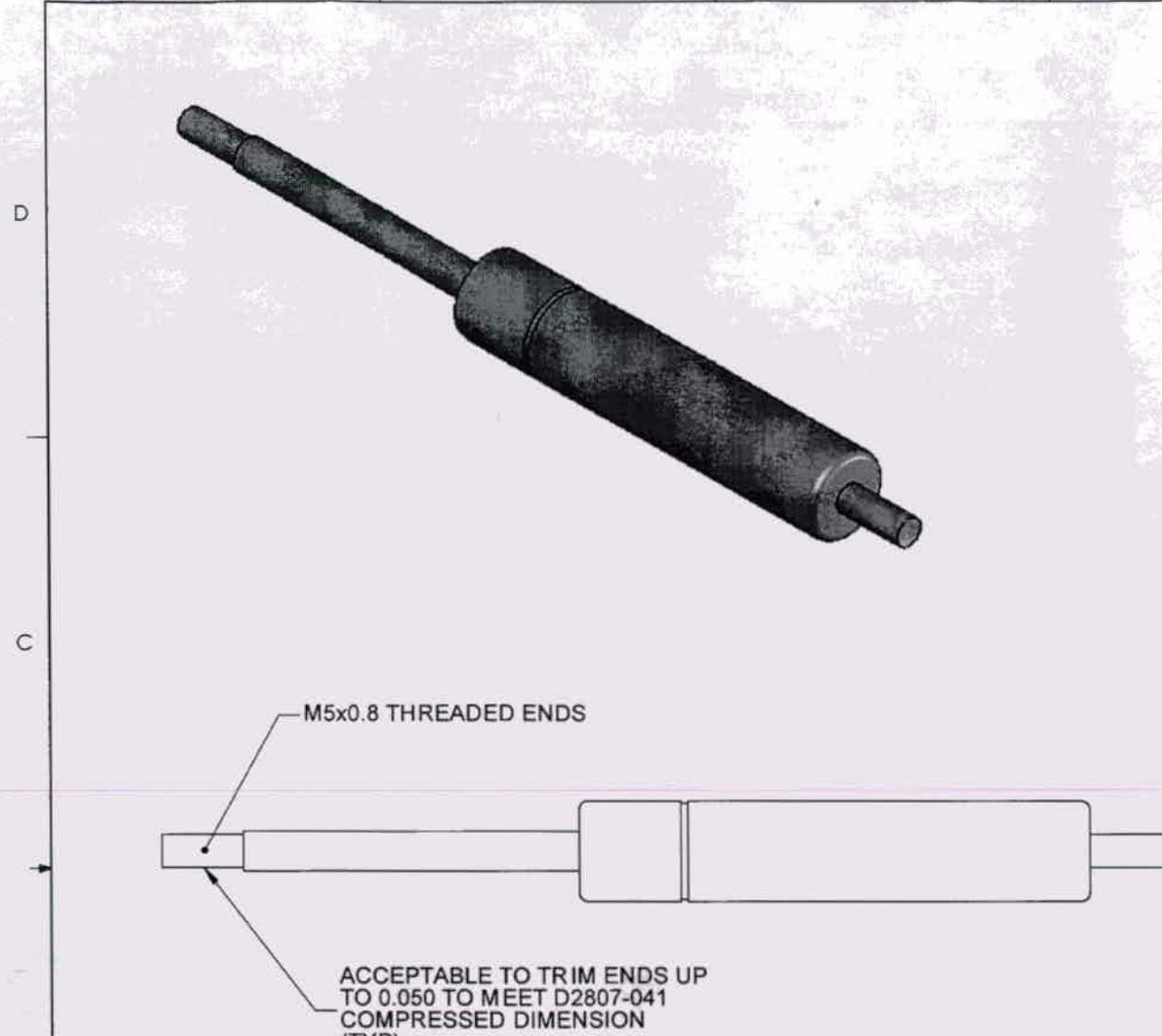
E

E	ADD D2807-5 GAS SPRING; D2807-1/3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	A	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	A	DRAWING NO. D2807 REV. E SHEET 1 OF 3 TITLE SCALE NTS	
CHECKED	E		
MFG. APPR.	A		
APPROVED	A		
DE APPR.	A		
DATE	07.12.28		

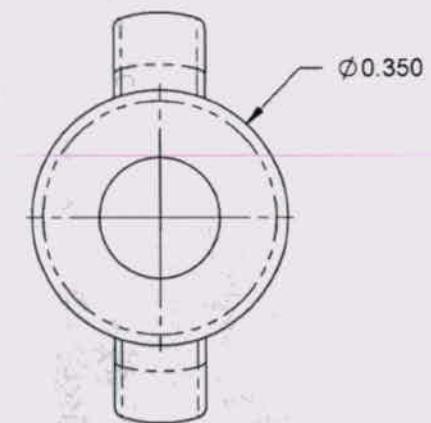
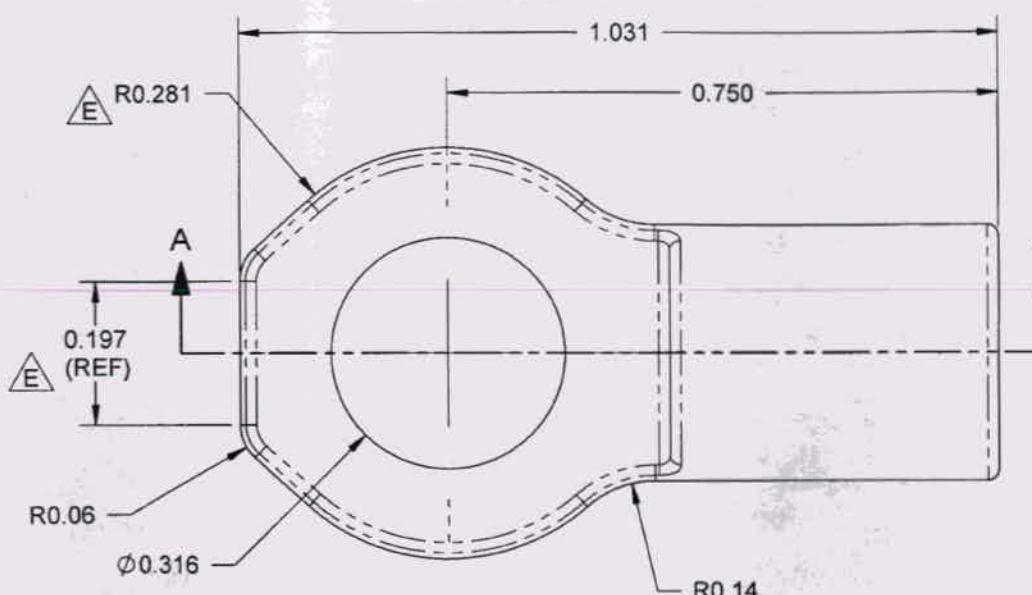
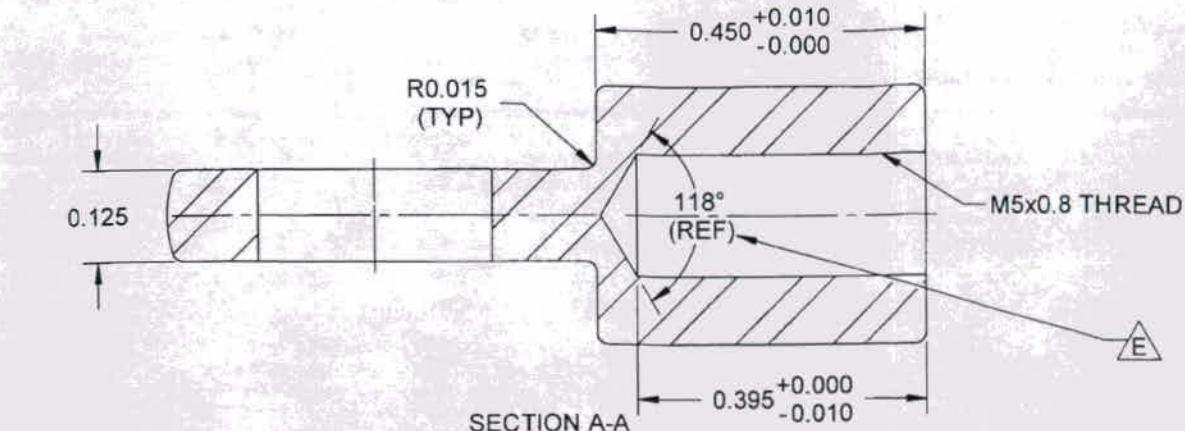
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8 7 6 5 4 3 2 1



D2807-1 GAS SPRING
SCALE 1:1



D2807-3 LUG

D2807-1 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK (P/N SXF6S6050080S6L-115N) (REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS

D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

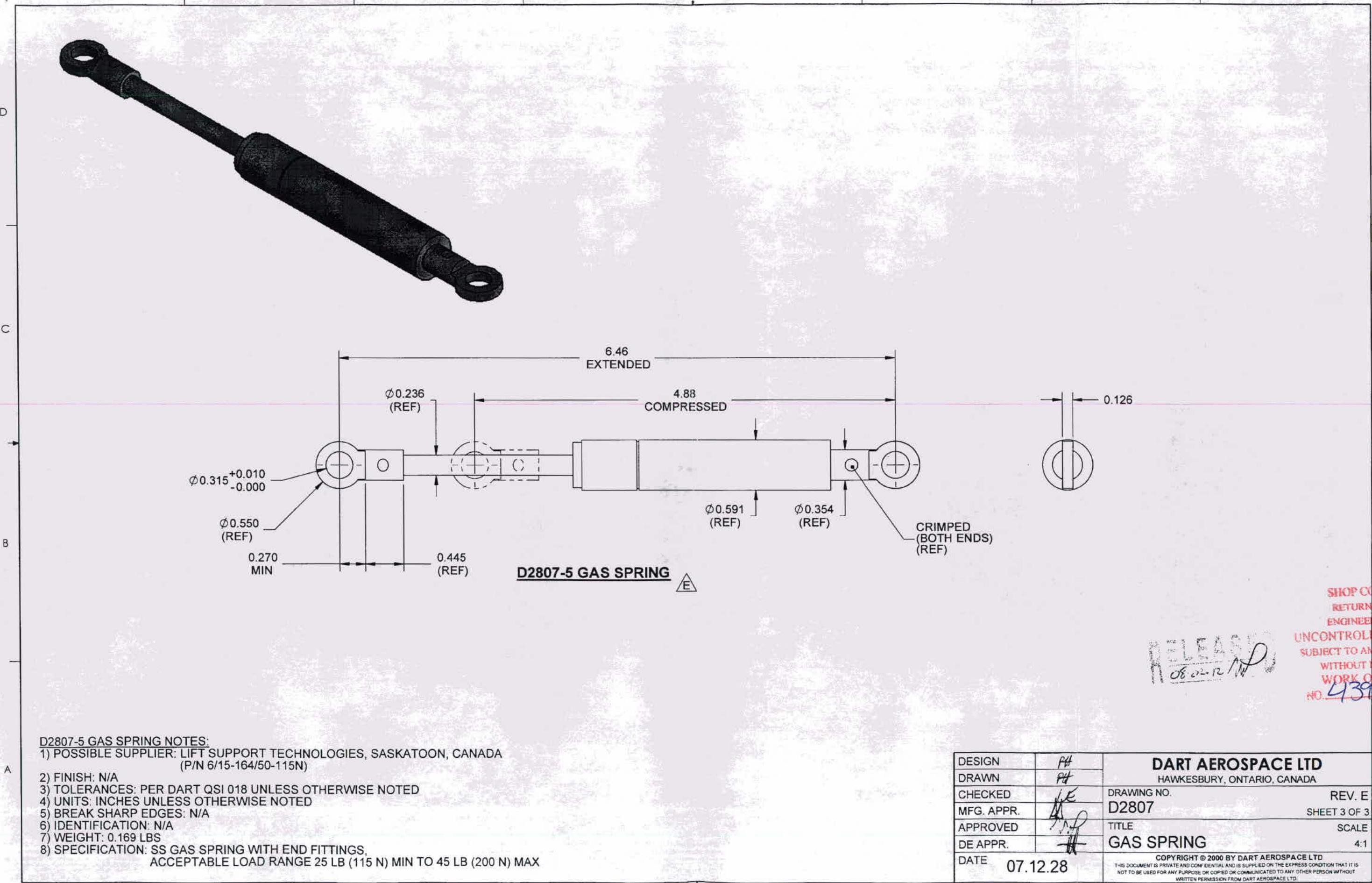
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WITHOUT NOTICE
WORK ORDER
NO. 4390

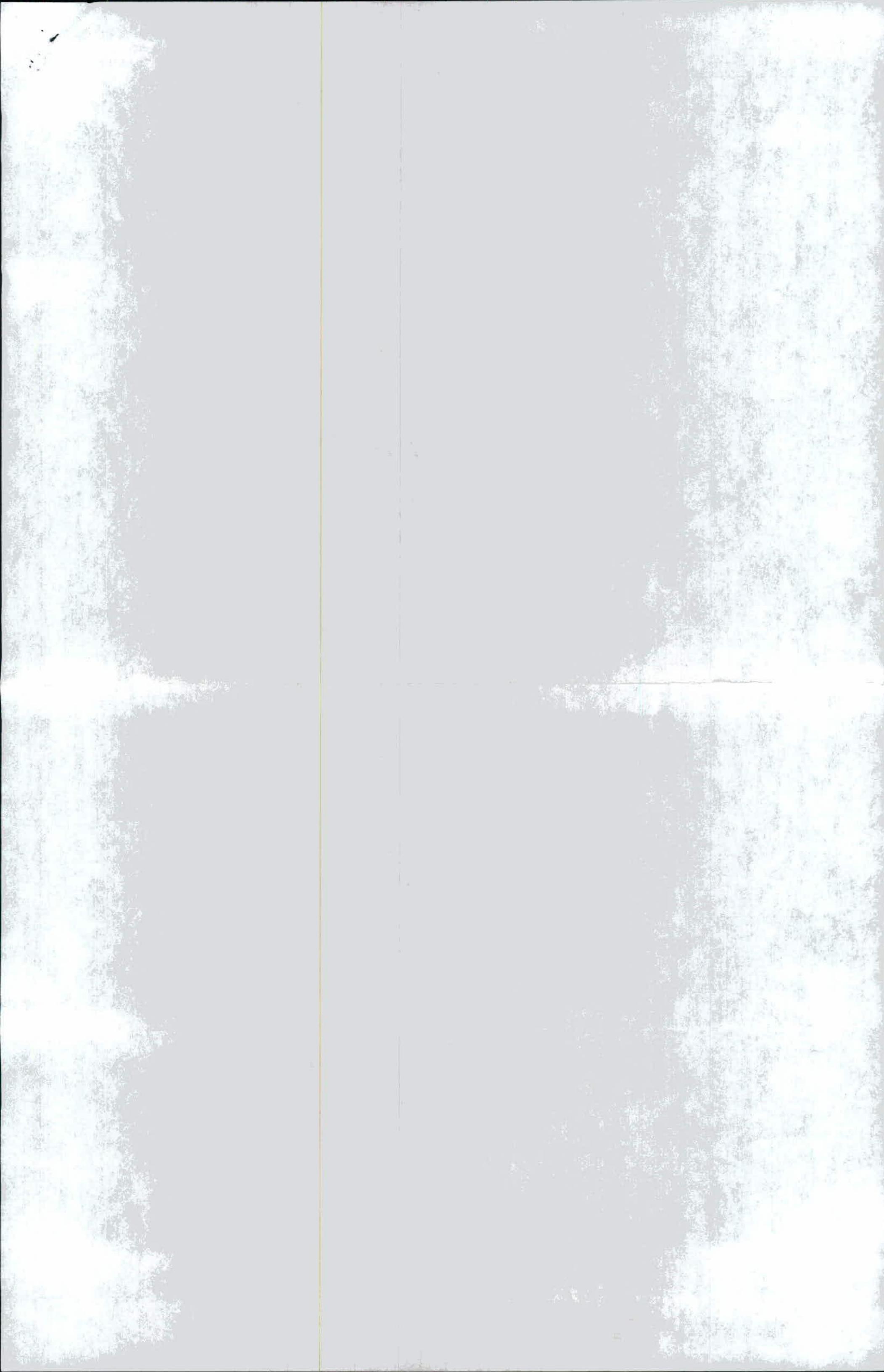
DESIGN	AA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AA	
CHECKED	EE	
MFG. APPR.	AA	
APPROVED	AA	
DE APPR.	AA	
DATE	07.12.28	REV. E SHEET 2 OF 3 SCALE 4:1

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ONE OUNCE
WATER + 1/2 OUNCE
ALCOHOL



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WITHOUT NOTICE
WORK ORDER
NO. 43901



LS Technologies Canada Inc.

303 - 103 Street
Saskatoon, SK
S7N 1Y9

Packing Slip

Date	Packing Slip #
12/15/2008	4606

Name / Address

Dart Aerospace Ltd
1270 Aberdeen St.
Hawkesbury, ON K6A 1K7
Canada

Ship To

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St.
Hawkesbury, ON K6A 1K7
Canada

P.O. No.

7765

Rep

Nolan

Ship Date

12/15/2008

Ship Via

Purolator

Qty	Description
10	D2807 - 6/15-056-168-115N Stainless Gas Spring Shipping via PUROLATOR Collect - Tracking # 329057690318 30 pcs on back order Total GST Business Number: 875007718

Please remit to above address. Thank you for the business.



P.O. Box 25032, Saskatoon, Saskatchewan, Canada S7K 8B7
Ph: (306) 683-5000 Fax: (306) 683-6403
E-mail: info@lstechnologies.ca
Web: www.lstechnologies.ca

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

10 Units: D2807 – 615 16450 115N Gas Spring

Country of Manufacture: Canada
Date of Manufacture : 2008
This product is ROHS compliant.

*S
06/21/07*

We certify no mercury was used in the manufacture of this order.

Purchase Order # 00007765

Invoice # 4606

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read "Nolan Fehr".

Nolan Fehr
Manager

